

Work Order ID 52316

Page 1

Tuesday, September 22, 2009 2:51:46 PM

Item ID: D3065-3

Accept



Setup Start



Revision ID: B

Stop



Item Name: Step Spacer

Start Date: 9/23/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 09-9-22

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3065	Rev B

100



FLOW WATER JET

Waterjet

Memo

0.00

BS 9-11-3

FLOW CNC Waterjet

1-Cut as per Dwg D Dwg Rev: B Prog Rev: B 2-Deburr
if necessary

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

BS 9-11-3

120



QC8- Inspect parts - second check

0.00

QC

Memo

0.00

Locn 4
HScrn
bk
q7 v1
Pwr
temp/lite
8

Quality Control

W/O: 52316		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
9/14/04	# 120	Took Qtry +1 for template for QC inspection		09.11.04	1	09.11.04	S 02/11/04

Part No: D3065-3 PAR #: Fault Category: Small Part / W.I NCR: Yes No DQA: Date: 09.11.04
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Date: 09.11.04

NCR: 52316		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/14/04	# 100	Found Qtry +1 Part with hole location not alignment Defect more Darkening w/3 R.C: Process 2	A action	=Scrap + Destroy no replace Qtry +1	B 9-11-04	S 6/11/04	A assess	S 02/11/04

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Deburr Stack

W/A done @ 100 /

140



NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

Bend as per Dwg D3065

SB 09/11/09
40 0

150



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

*40
counted*
10/11/09

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Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

M

09/10/11

40X

0

Hand Finishing

170



QC

QC3- Inspect Part Finish

0.00

BF 09-11-10

40

Quality Control

180



Packaging

Identify as per dwg & Stock Location: GA

0.00

Memo

0.00

BB 09/11/10 40

Work Order ID 52316

Page 4

Tuesday, September 22, 2009 2:51:46 PM

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Start Date: 9/23/2009 Start Qty: 40.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

09/11/10

MF
09-11-10

Picklist Print

Page 1

Tuesday, September 22, 2009 2:51:45 PM

Work Order ID: 52316



Parent Item: D3065-3RevB



Parent Item Name: Step Spacer

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 40.00

Required Qty: 40.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased		No		100	sf	220.2565	9.1705			BB 9-113

2024-T3 .040 sheet

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT	220.2564789	
110337	6.4	
111786	39.0665789	
112291	91.9258	
112331	82.8641	

112291

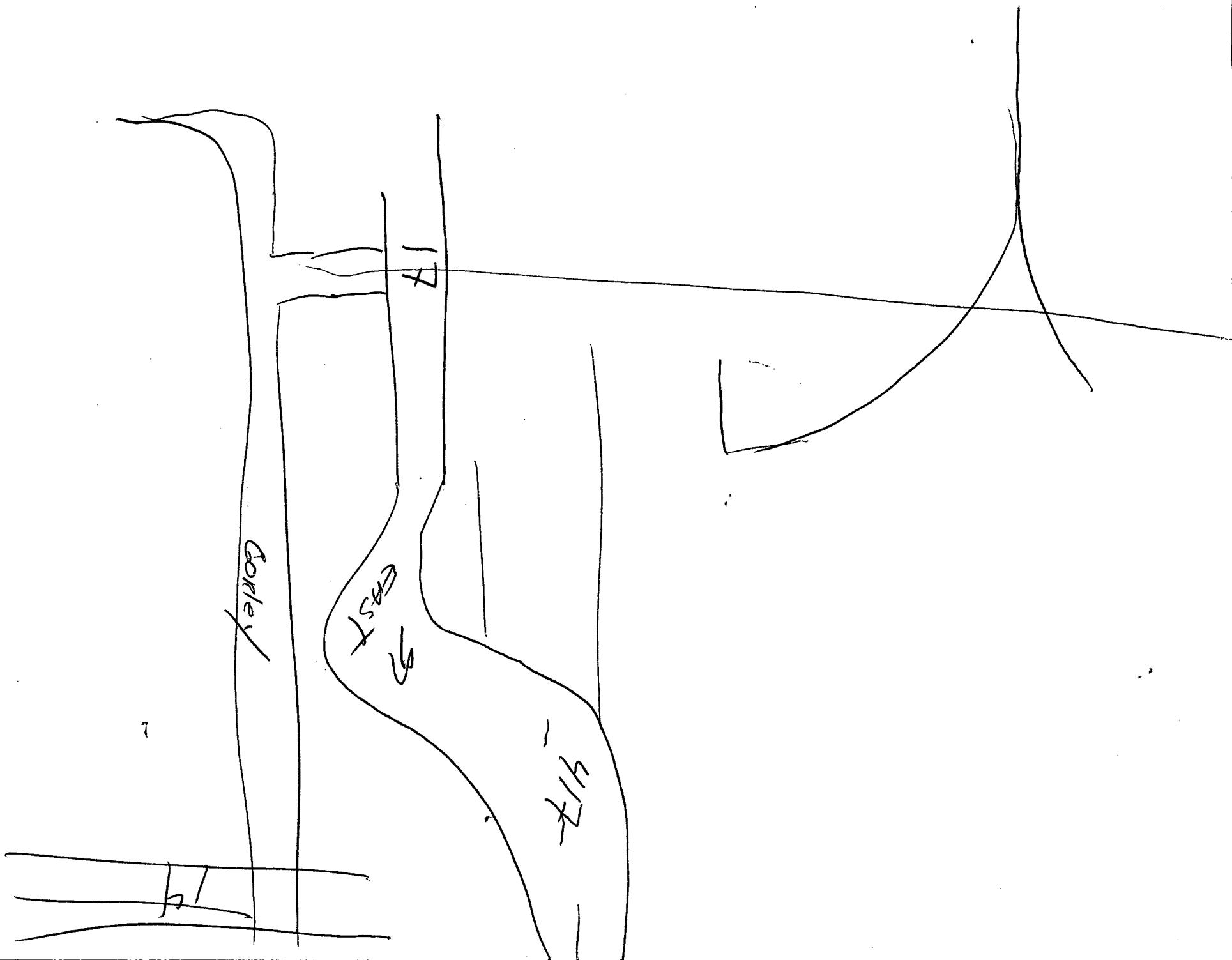
DART AEROSPACE LTD	Work Order:	52316
Description: Step Spacer	Part Number:	D3065-3
Inspection Dwg: D3065	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>AB</u>	Audited by:	<u>S</u>	Prototype Approval:	N/A
Date:	9-11-3	Date:	01/11/14	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.25	New Issue P/O D3065-041	KJ/RF	
B	04.08.12	Removed dimension 1.204	KJ/JLM	
C	06.06.23	Dwg Rev. changed	KJ/JLM	
D	07.09.06	0.040 dimension added	KJ/JLM	Z



SHOP COPY

RETURN TO

UNCO ROYAL CO /
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

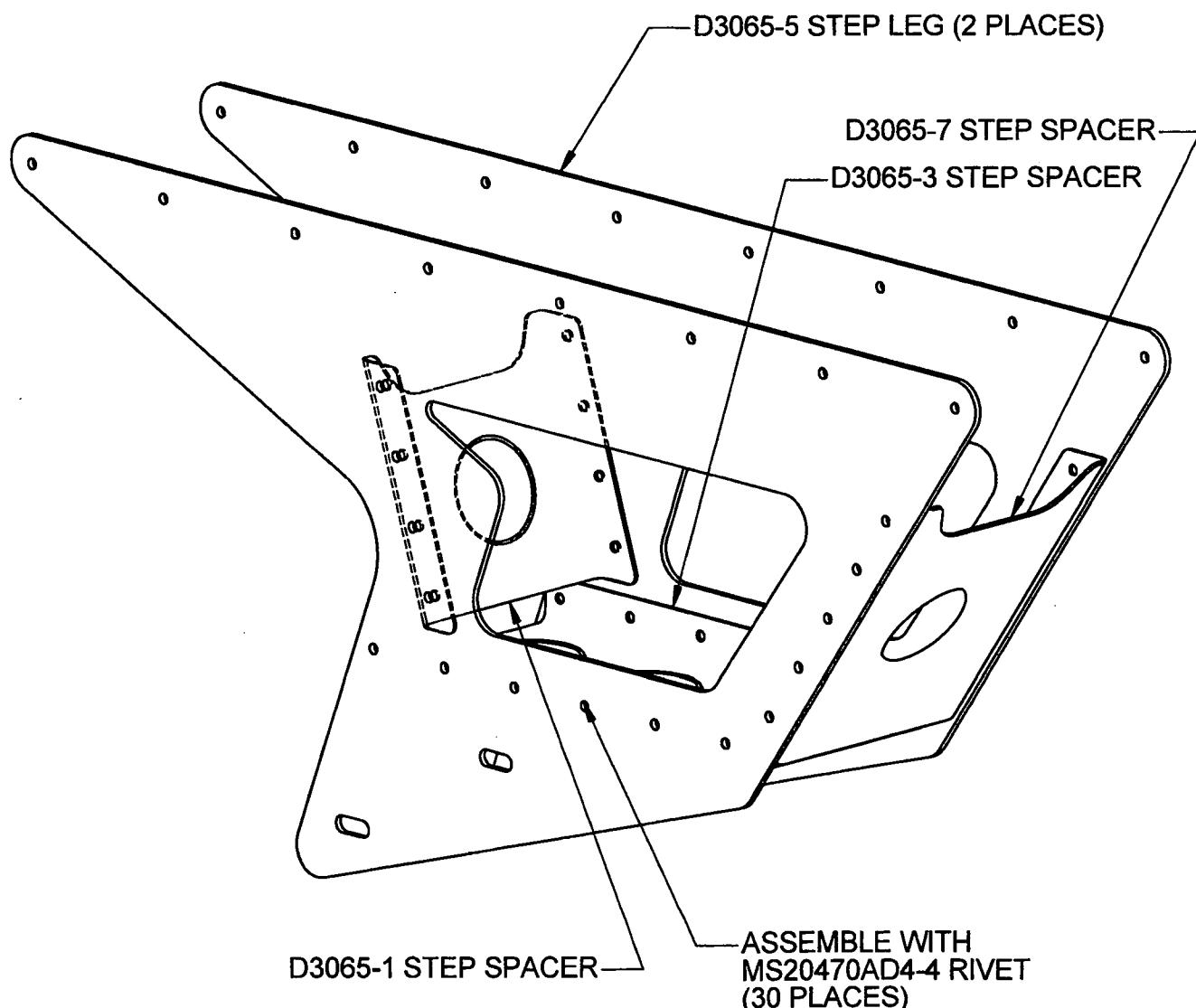
NO. 52876

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. B
<u>PH</u>	<u>SH</u>	D3065	SHEET 1 OF 5
DATE	06.05.23	TITLE	SCALE
		STEP LEG ASSEMBLY	1:2
A	02.09.11	NEW ISSUE	
B	06.05.23	ADD 6061-T6 MATERIAL, ADD SLOTS TO D3065-5	

RELEASED

06.06.20 SH



D3065-041 STEP LEG ASSEMBLY

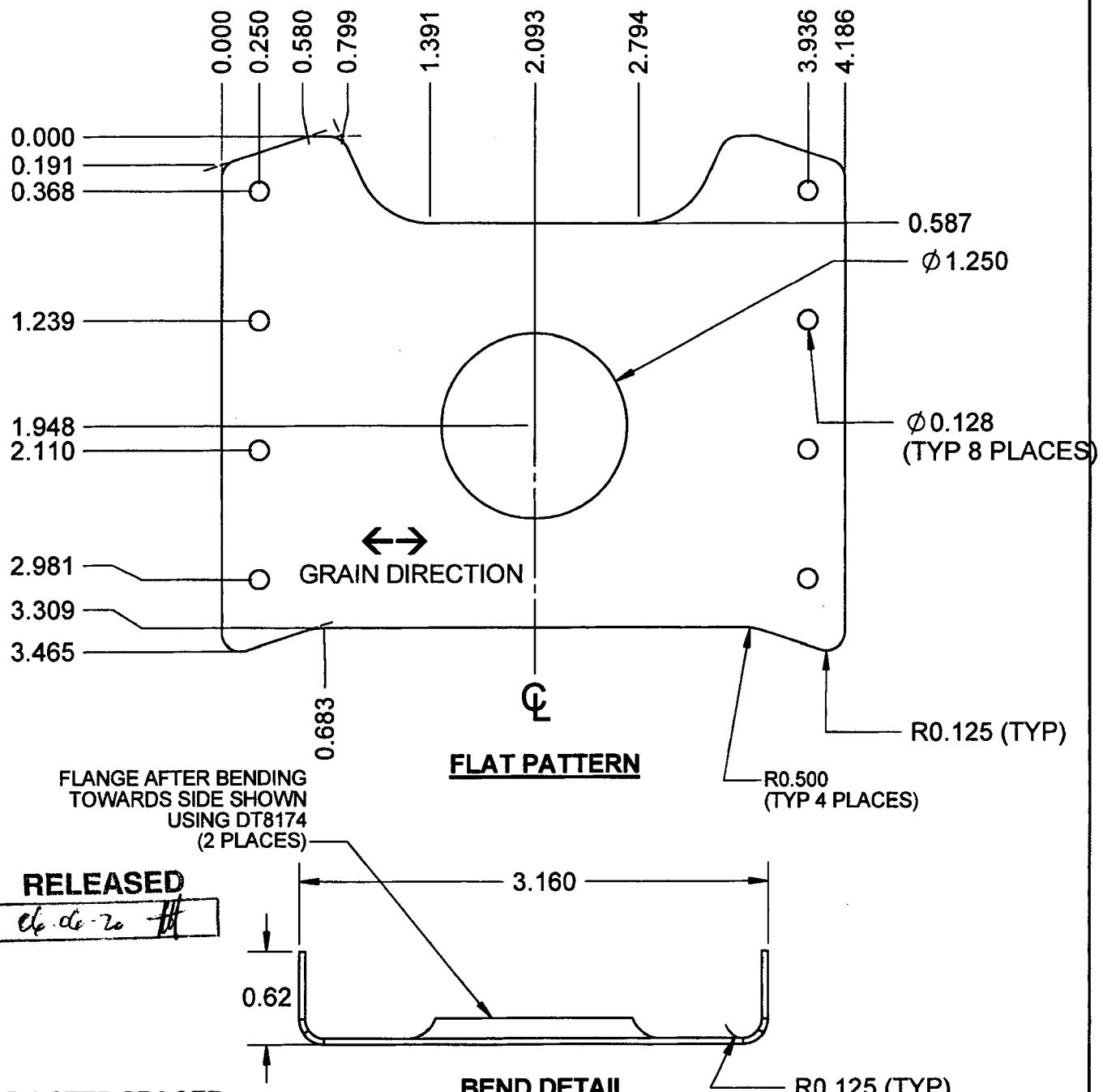
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DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>M</i>	DRAWING NO. D3065
DATE 06.05.23	TITLE STEP LEG ASSEMBLY	REV. B SHEET 2 OF 5 SCALE 1:1

52314



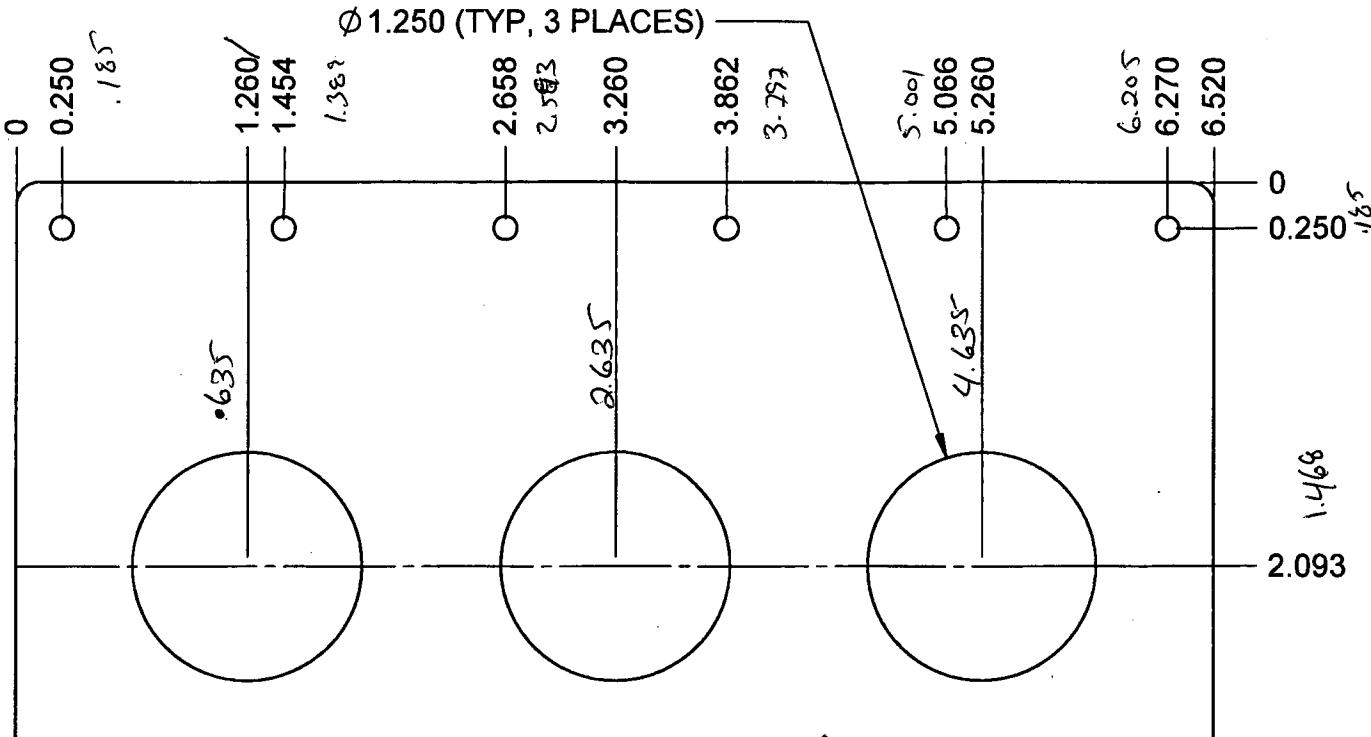
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) PART IS SYMMETRIC ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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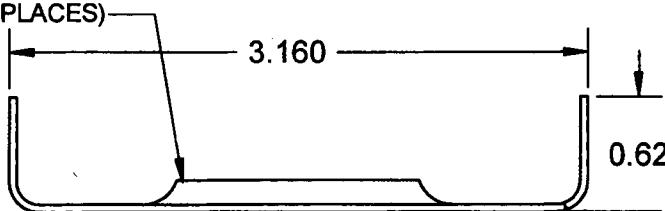
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52816
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3065
DATE	06.05.23	TITLE STEP LEG ASSEMBLY

REV. B
SHEET 3 OF 5
SCALE
1:1**FLAT PATTERN**

GRAIN DIRECTION

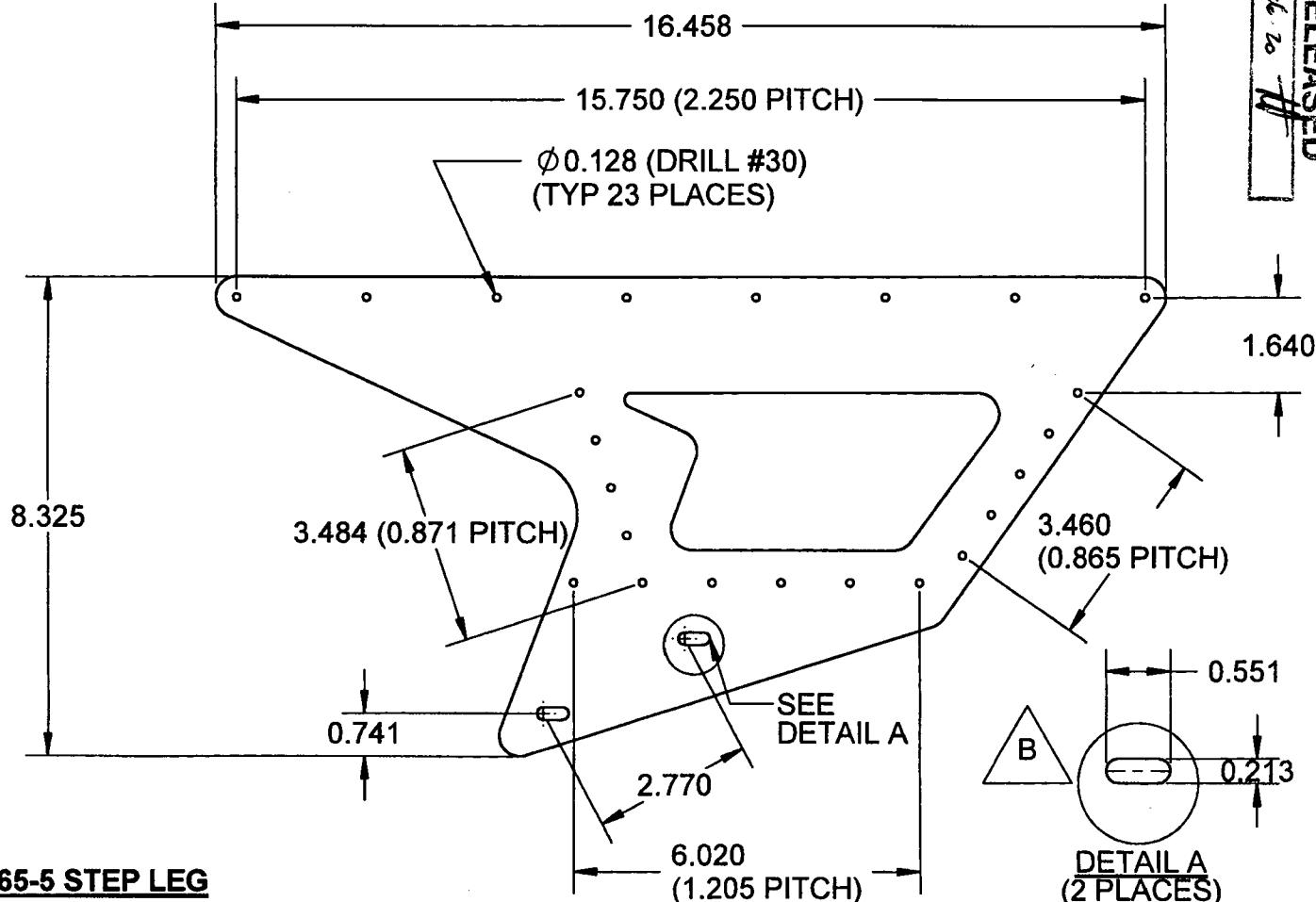
FLANGE AFTER TOWARDS SIDE
SHOWN USING DT8174 (3 PLACES) $\phi 0.129$ (TYP, 12 PLACES)**RELEASED**06.05.23 - ~~11~~**D3065-3 STEP SPACER**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4)
0.040 THICK (REF DART SPEC. M2024T3S.040)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 3) PART IS SYMMETRIC ABOUT CENTERLINE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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52316

DART**RELEASED**
06.06.06**D3065-5 STEP LEG**

- 1) MACHINE PER DWG FILE "D3065-5.SLDPRT"
- 2) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32 (PER QQ-A-250/8 OR AMS 4016) 0.080 THICK (REF DART SPEC. M5052H32S.080)
- 3) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

DESIGN	DRAWN BY	DART AEROSPACE LTD
40	C.B	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
P.H.	M.	D3065
DATE	TITLE	REV. B
06.05.23	STEP LEG ASSEMBLY	SHEET 4 OF 5
		SCALE
		1:3

52314

DART

DESIGN <i>CP</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>PH</i>	APPROVED <i>CH</i>	DRAWING NO. D3065
DATE 06.05.23		REV. B SHEET 5 OF 5 TITLE STEP LEG ASSEMBLY SCALE 1:1

